

# Work Order ID 68397

Tuesday, April 12, 2011 3:35:51 PM



## PRELIMINARY ISSUE

Page 1

Item ID: D4365-1

Accept



Setup Start



Revision ID: PRELIM

Item Name: Bar

Stop



Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:



Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-04-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4365

PA1

100

0.00



Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 43.500"

*[Signature]* 11/04/26

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB040 & dwg D4365,

FOLIO REV: \_\_\_\_\_

DWG REV: \_\_\_\_\_

2-Deburr as required

Manual Mill

*[Signature]* 11/04/26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68397**

Tuesday, April 12, 2011 3:35:52 PM



Page 2

Item ID: D4365-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bar

Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/04/26

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11/04/26

1

140

0.00



Small Fab

Memo

0.00

Small Fab

Grind off chamfer on fwd end of bar as per dwg

11/04/26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 68397

Tuesday, April 12, 2011 3:35:52 PM



Page 3

Item ID: D4365-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Bar

Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00 - inspected bpa1



QC

Memo

0.00

Quality Control

Done only  
8/16/12

160

Identify as per dwg & Stock Location: 030

0.00



Packaging

Memo

0.00

Packaging

Welding area

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11/04/13

RELEASED \_\_\_\_\_

AUTH

DATE

FD2382

MF  
11-04-27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, April 12, 2011 3:35:58 PM

Page 1

Work Order ID: 68397

Parent Item: D4365-1

Parent Item Name: Bar





Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.04.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500 		Purchased	No			100	f	269.5000	3.625	3.815789			
304 BAR .250 x .500													

Location

Loc Qty

Loc Code

MAT006

78

116148

78

MAT050

191.5

117176

191.5

3.7

*11/04/26*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

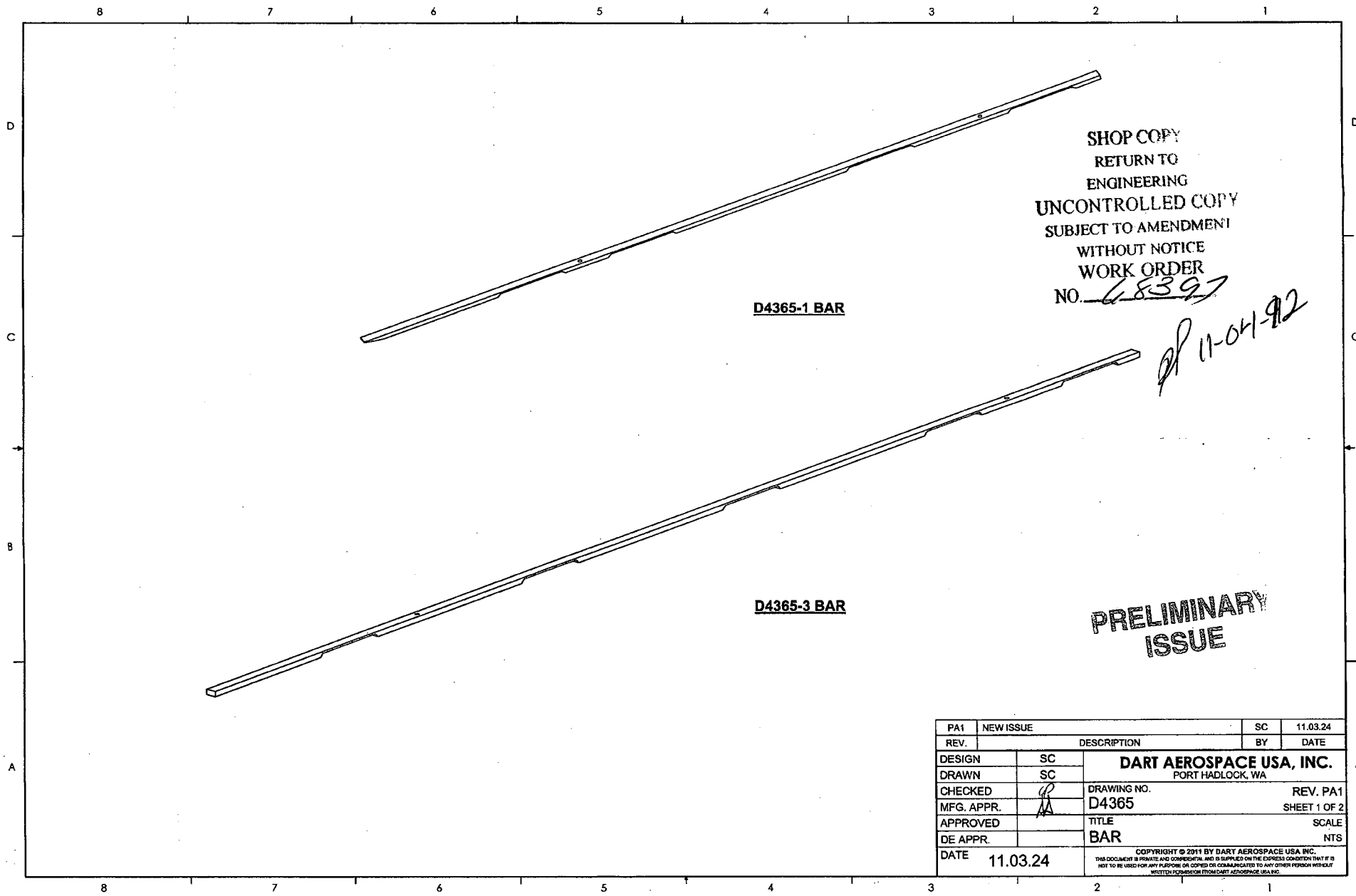
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 68397

*11-04-92*

**D4365-1 BAR**

**D4365-3 BAR**

**PRELIMINARY  
 ISSUE**

PA1	NEW ISSUE	SC	11.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>PA</i>	DRAWING NO.	REV. PA1
MFG. APPR.		<b>D4365</b>	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>BAR</b>	NTS
DATE	11.03.24	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES						
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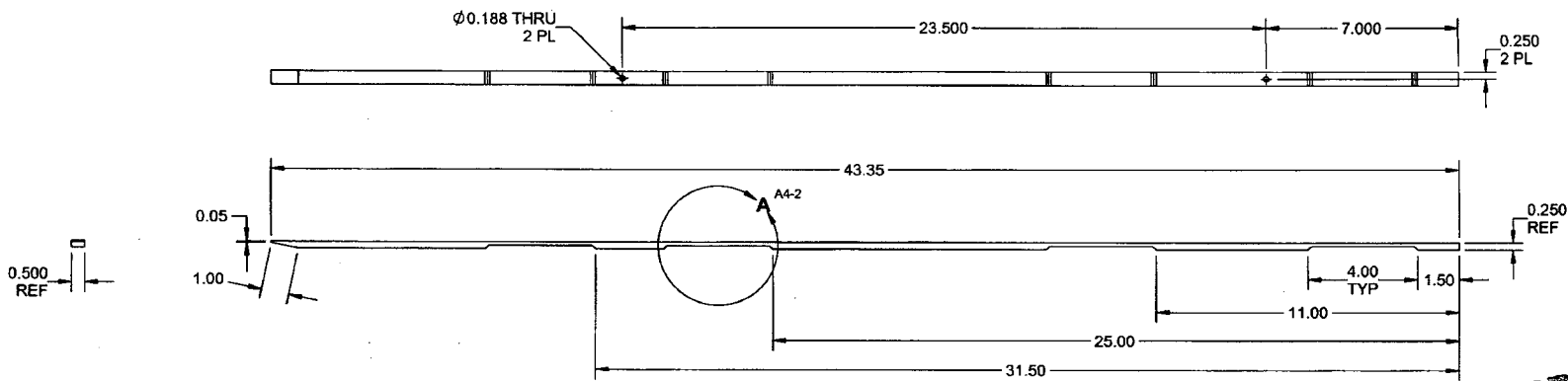
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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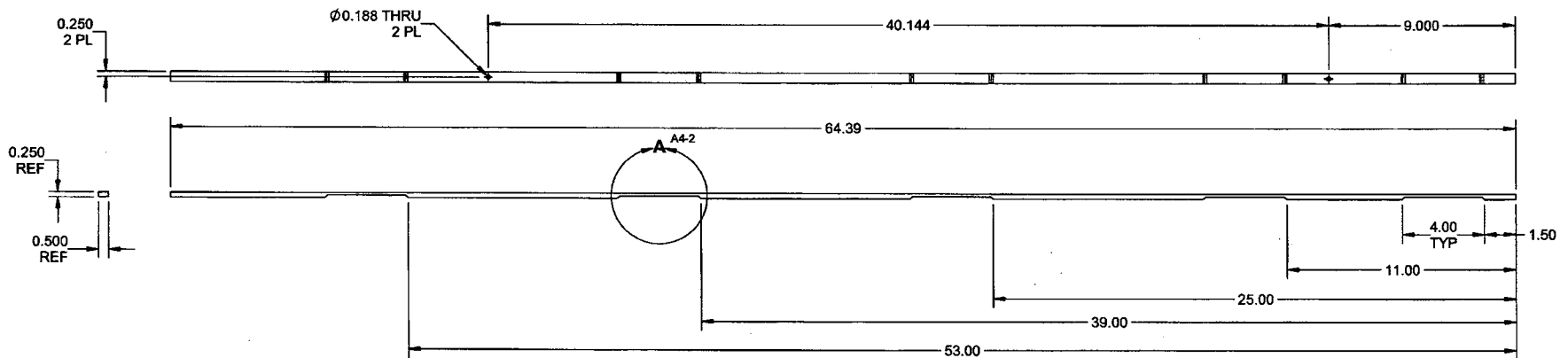
8 7 6 5 4 3 2 1



**D4365-1 BAR**

W/O 68397

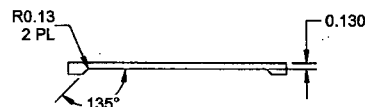
**PRELIMINARY  
ISSUE**



**D4365-3 BAR**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR. 0.250 THICK X 0.600 WIDE  
PER ASTM A276 OR ASTM A240  
REF. DART SPEC. M304B0.250X00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4365-1 = 1.28 lbs  
D4365-3 = 1.98 lbs



**DETAIL A  
TYP**

B5-2  
D5-2

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. PA1
MFG. APPR.	JP	<b>D4365</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>BAR</b>	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES						
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